

Work Order ID 67842 -1 Split

Thursday, March 31, 2011 3:47:45 PM



Page 1

Item ID: D3016-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Frame Assembly

Start Date: 4/1/2011

Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: H

Date: 11-03-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3016

RevA / DEO A-1

100

Weld per dwg A/R 4130 rod Batch M100075 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

5- Assemble brackets and gusset per dwg and weld

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

EL 11-9-11 (X1)
1 0 BE 11/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref.4 3.5 6) per QSI005 4 3

0.00



Powdercoat

Memo

0.00

Powder Coating

Install paint screws on fitting ends

START TIME: 1230

OVEN TEMPERATURE: 400

FINISH TIME: 1:00

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/6/12

71
set

11 04 21 ①

5/11/04/25 ①

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Page 3

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Start Date: 4/1/2011 Start Qty: 1.00



Required Date: 4/7/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

Identify as per dwg & Stock Location: *GA*

0.00



Packaging

Memo

*w/o
67840*

0.00

Packaging

JS 4/04/25

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/25

MF

11-04-25

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 3:47:54 PM

Page 1

Work Order ID: 67842

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly



Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.049

Purchased

No

100

f

85.2300

4.3

4.526316



4130 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT033

85.23

10.73

74.5

10.73

4.5' x 4.66'

M4130NT0.500W.049

Purchased

No

100

f

81.8400

4.3

4.526316



4130 RD Tube .500 x .049W

Location

Loc Qty

Loc Code

MAT032

81.84

7.09

74.75

7.09

106651

110740

3

M4130NT1.000W.120

Purchased

No

100

f

1.2200

1.5

1.578947



4130 RD Tube 1.00 x .120wall

Location

Loc Qty

Loc Code

MAT033

1.22

1.22

1.22

M117378 x 1.08'

113665

D3016-17

Manufactured

No

100

Each

6.0000

2

2



Gusset

Location

Loc Qty

Loc Code

WA019

6

6

64618

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 3:47:55 PM

Work Order ID: 67842

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13

Manufactured No

100 Each

14 0000

2 2



Bracket



EL 11-4-21

Location

Loc Qty

Loc Code

WA019

14

44778

14

D3016-15

Manufactured No

100 Each

5 0000

2 2



Gusset



B 11-4-21

Location

Loc Qty

Loc Code

WA019

5

43413

5

D3020-1

Manufactured No

100 Each

33.0000

4 4



Fitting



EL 11-4-20

Location

Loc Qty

Loc Code

WA

33

36713

33

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO:
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67842
2811-03-31

DEO ATTACHED

RELEASED
01.05.30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

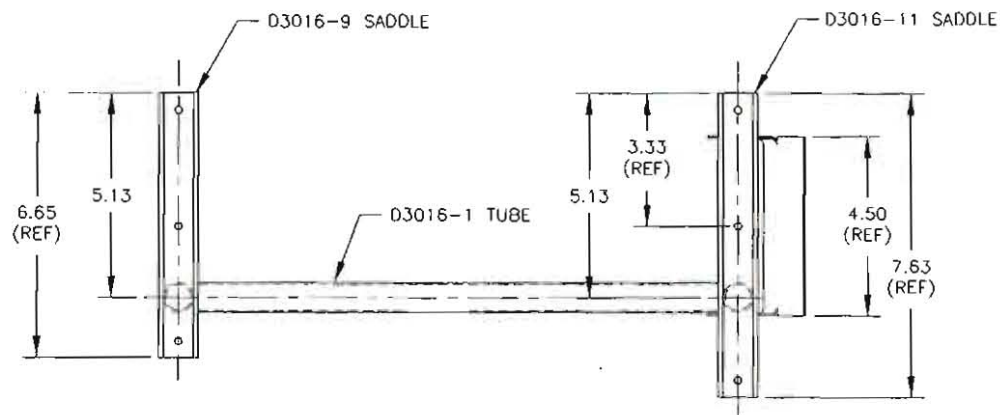
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

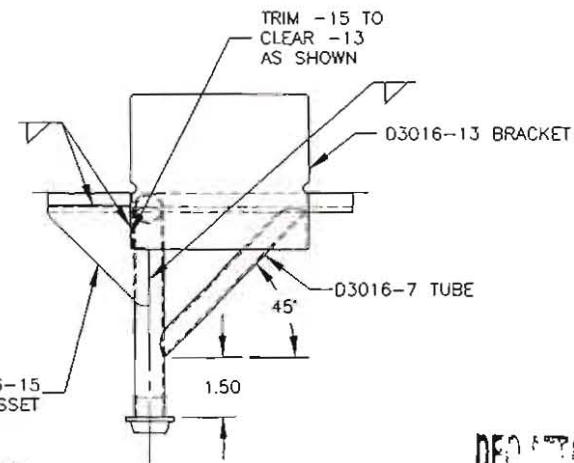
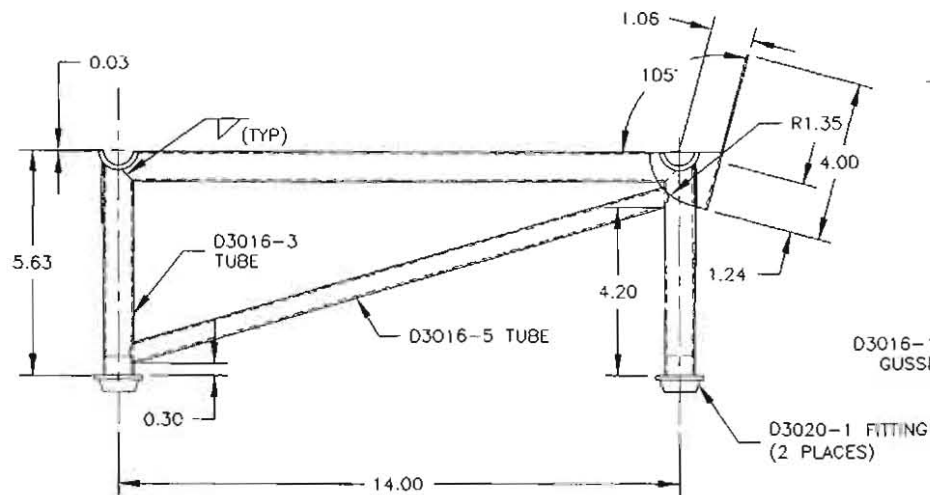
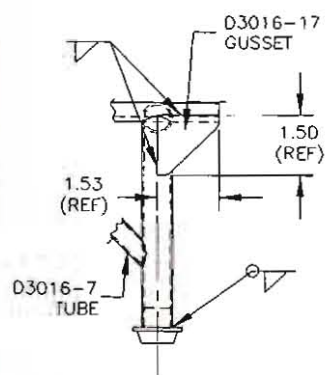
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

D3016-041 SEAT FRAME ASSEMBLY



u10 47842



DETACHED
RELEASED
01.05.18

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DESIGN UP	DRAWN BY UP	DART	DART AEROSPACE LTD. THUNDERBAY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3016	REV A SHEET 2 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE 1:3

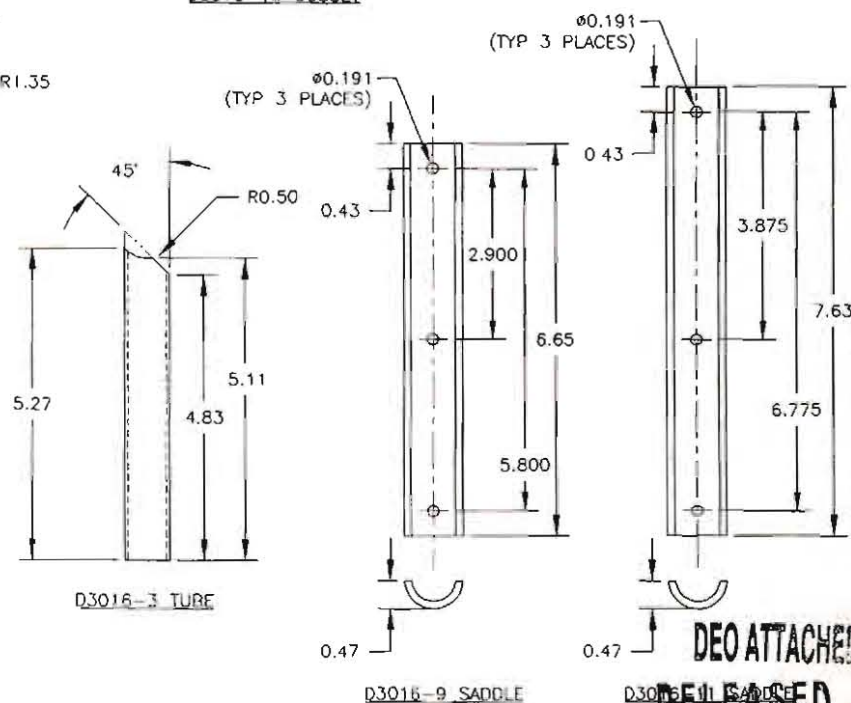
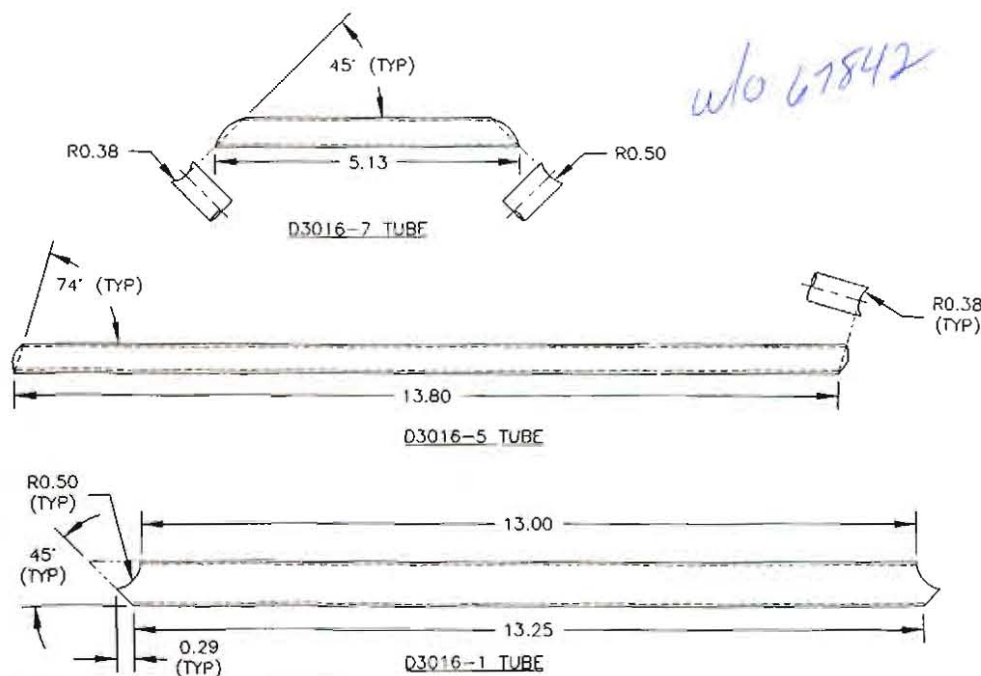
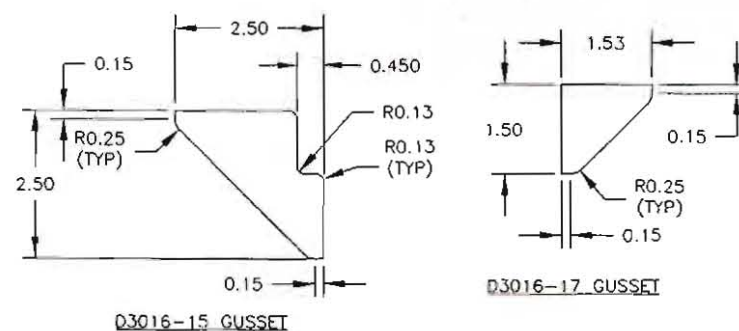
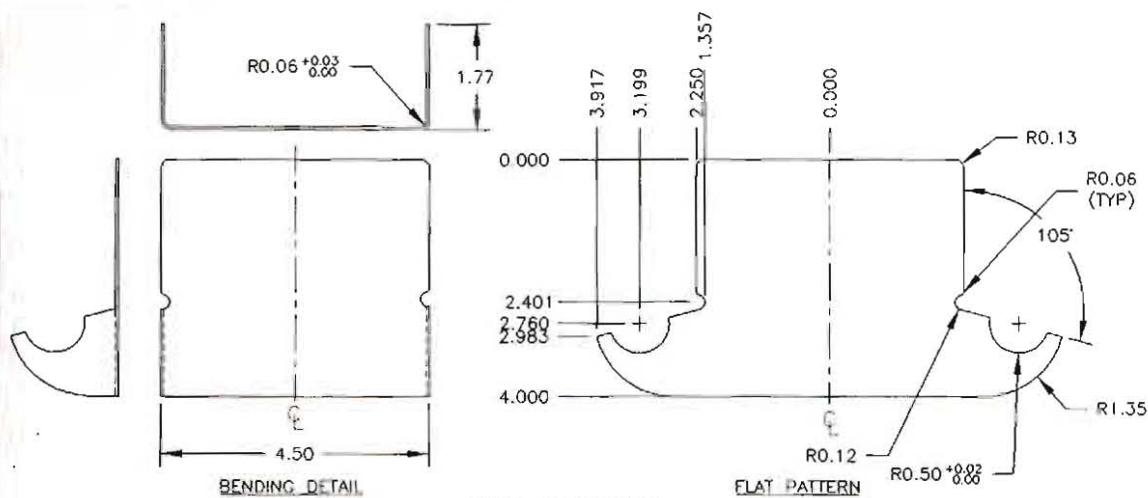
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DESIGN CP

DRAWN BY CP

DART

DART AEROSPACE LTD.

MARKHAM, ONTARIO, CANADA

CHECKED *[Signature]*

APPROVED *[Signature]*

DRAWING NO.

D3016

REV. A

DATE

01.05.18

TITLE

SEAT FRAME ASSEMBLY

SHEET 3 OF 3

SCALE

1:2

DEO ATTACHED

RELEASED
9.05.30

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>WAP</i>	DE APPR. <i>WAP</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

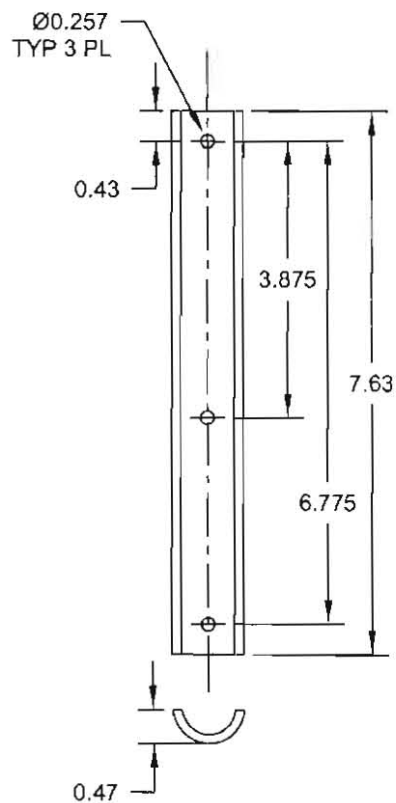
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

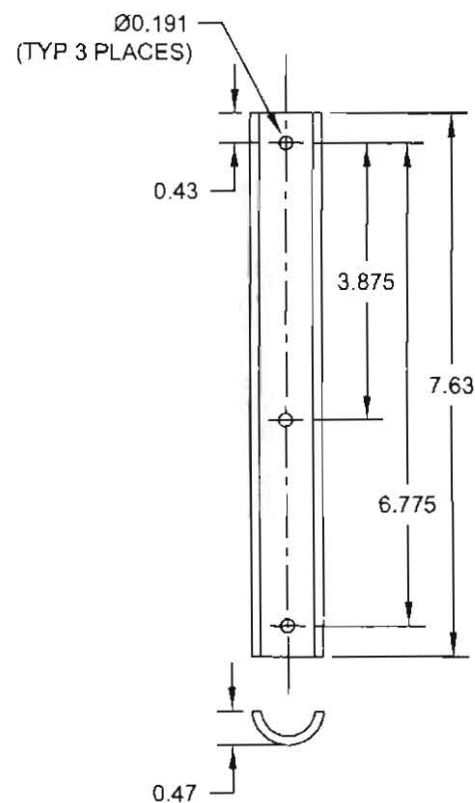
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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